

# Work Order ID 65766

Tuesday, January 25, 2011 10:30:27 AM

Page 1

Item ID: D4037-3

Accept

Revision ID:

Item Name: Fwd Crossbeam

Start Date: 1/25/2011 Start Qty: 2.00

Required Date: 1/28/2011 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan: *M*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4037

C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut blank as per file D4037-3\_BLANK

B11-1-26

*2*

110

0.00



HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA878 AND DWG

FOLIO REV: AA

DWG REV: C

DEBURR

*G.A 11/01/27*

*2*

*φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID: D4037-3

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Setup Start

Revision ID:

Stop

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Start Date: 1/25/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Y.A 11/01/27

2

φ

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SL 11/01/31

(2)

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

⇒ H 11/01/31 x2 φ

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Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

MU5951.

Memo

START 11:45

FINISH 12:15

QUENT 320°

2 BR 11-01-31

160

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

=> H 11/01/31 X2 0

170

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Memo

0.00

11/01/31 X

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/01/31 [Signature]

11-01-31

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# Picklist Print

Tuesday, January 25, 2011 10:30:24 AM

Page 1

Work Order ID: 65766

Parent Item: D4037-3

Parent Item Name: Fwd Crossbeam



Start Date: 1/25/2011

Required Date: 1/28/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC  
REV:B AS PER REV B 10-04-19 JLM VERIFIED BY:EC  
C:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD  
IPP  
IPP REV

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X15.00 0		Purchased	No			100	f	38.0900	3.9	8.210526			



6061-T6 Bar 1.00 x 15.00



IB1-1-26

Location	Loc Qty	Loc Code
MAT	36	
114899	12	
115093	12	
115173	12	
MAT07	2.09	
9544	2.09	

115093

2

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 65766
<b>Description:</b> Fwd Crossbeam		<b>Part Number:</b> D4037-3
<b>Inspection Dwg:</b> D4037	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
41.66	+/-0.030	41.660	✓		TAPE	GA-12
0.92	+/-0.030	0.918	✓		vern	GA-01
1.75	+/-0.030	1.750	✓		"	"
0.92	+/-0.030	0.918	✓		"	"
2.125	+/-0.010	2.125	✓		"	"
Ø0.316	+0.006/-0.001	Ø0.317	✓		"	"
Ø0.391	+0.006/-0.001	Ø0.395	✓		"	"
0.28	+/-0.030	0.285	✓		"	"
1.32	+/-0.030	1.310	✓		"	"
7.79	+/-0.030	7.788	✓		vern	CNC-02
5.80	+/-0.030	5.800	✓		vern	GA-01
2.250	+/-0.010	2.250	✓		"	"
0.875	+/-0.010	0.873	✓		"	"
6.000	+/-0.010	6.000	✓		"	"
7.75	+/-0.030	7.753	✓		vern	CNC-02
1.125	+/-0.010	1.125	✓		vern	GA-01
9.29	+/-0.030	9.290	✓		vern	CNC-02
1.75	+/-0.030	1.743	✓		vern	GA-01
1.38	+/-0.030	1.368	✓		"	"
1.50	+/-0.030	1.500	✓		"	"
0.63	+/-0.030	0.627	✓		"	"
1.00	+/-0.030	0.987	✓		"	"
10.79	+/-0.030	10.792	✓		vern	CNC-02
3.00	+/-0.030	3.001	✓		vern	GA-01
2.00	+/-0.030	2.002	✓		"	"
0.25	+/-0.030	0.257	✓		Mic	118-120
0.530	+/-0.010	0.523	✓		vern	GA-01
0.35	+/-0.030	0.347	✓		"	"
0.35	+/-0.030	0.347	✓		"	"
R0.13	+/-0.030	R 0.125	✓		R-6	ref.

<b>Measured by:</b> M.A	<b>Audited by:</b> JL	<b>Preliminary Approval:</b>
<b>Date:</b> 11/01/27	<b>Date:</b> 11/01/31	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	10.10.07	Dimensions updated per Dwg Rev C	KJ	

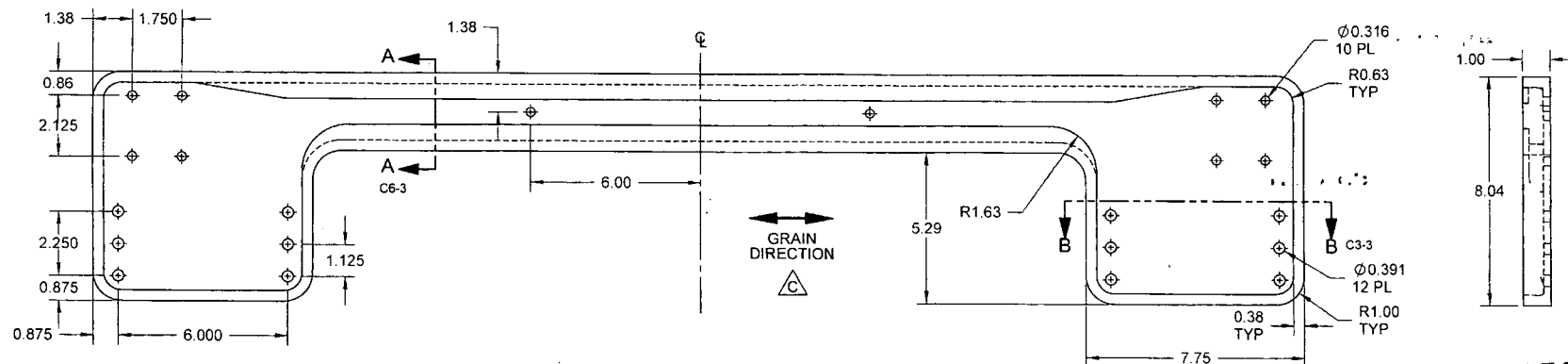
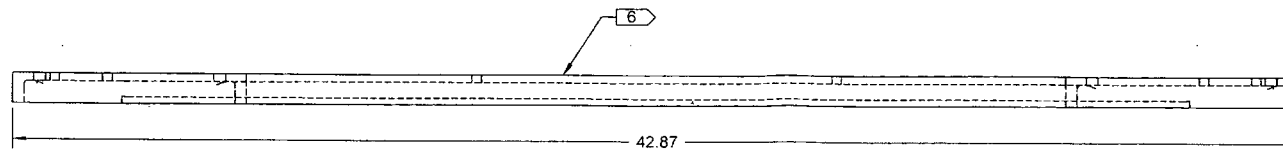
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NOTE: Date & initial all entries



**D4037-1 AFT CROSSBEAM**

**RELEASED**  
2010-09-27

*who 65746*

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S1.000
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 8.48 lbs
  - 8) MACHINE PER DART SOLIDWORKS PART "D4037-1\_REV.C.SLDPRT"

C	MODIFY -3 PART FOR CLEARANCE HOLES, SHT 2; UPDATE MATERIAL SPEC SHT 1, 2; 8.05 WAS 9.83; ADD GRAIN DIRECTION	HS	10.09.15
B	ADJUST DIMS AND REPOSITION HOLES, ZN B4-1, C8-1, C8-2	HS	10.02.10
A	NEW ISSUE	HS	09.12.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.15		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4037</b>	REV. C
TITLE <b>CROSSBEAM</b>	SCALE NTS
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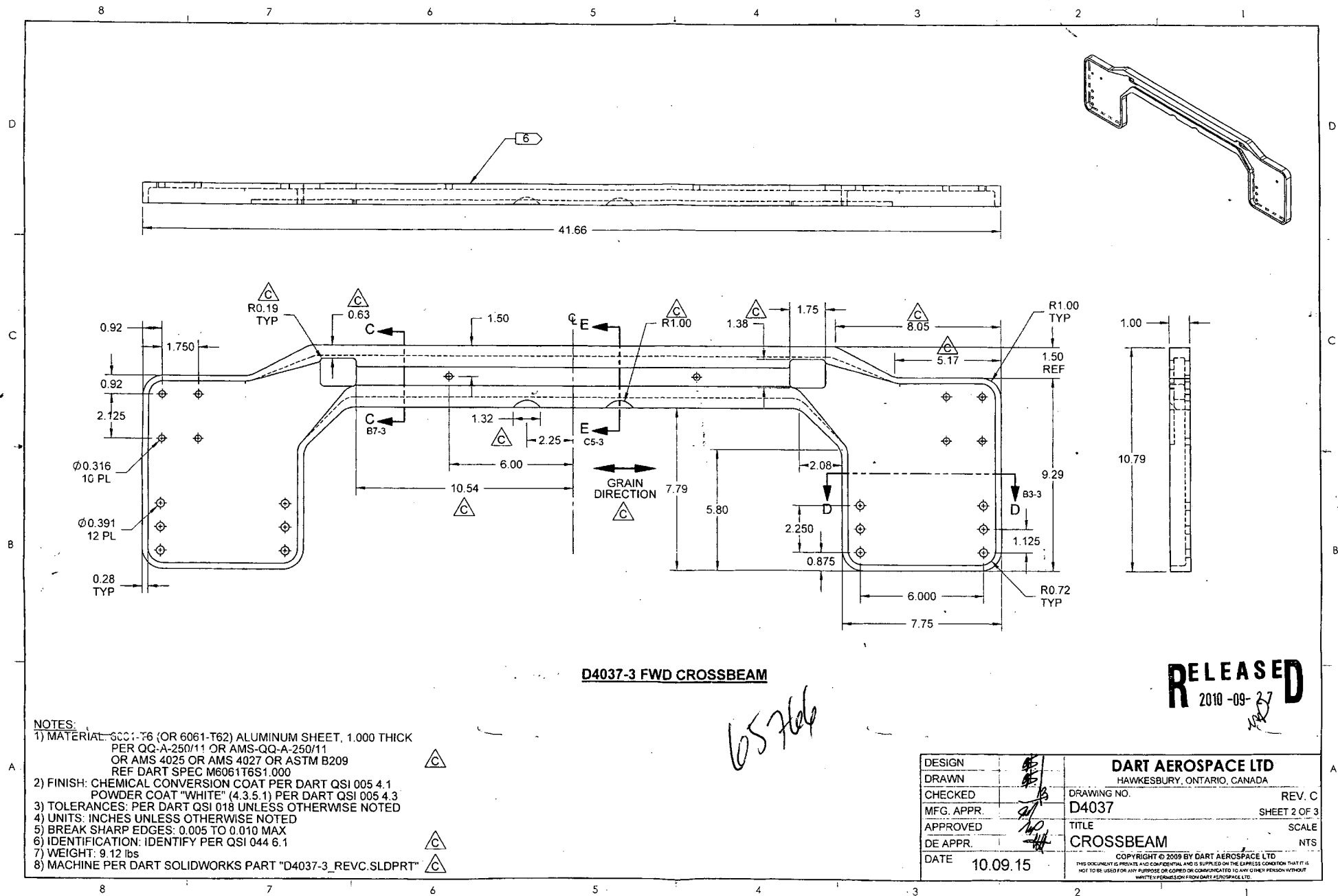
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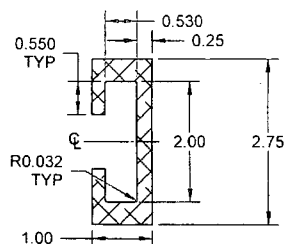
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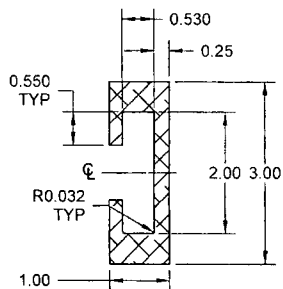
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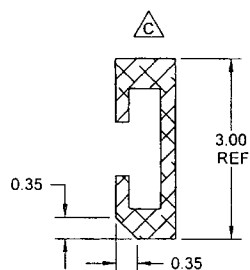




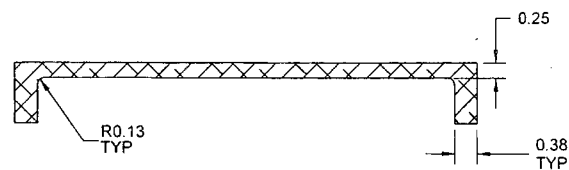
**SECTION A-A** B6-1  
SCALE 2X



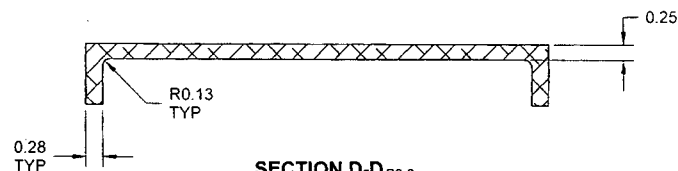
**SECTION C-C** B6-2  
SCALE 2X



**SECTION E-E** C5-2  
SCALE 2X



**SECTION B-B** B2-1  
SCALE 2X



**SECTION D-D** B3-2  
SCALE 2X

**RELEASED**  
2010-09-23

*65766*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4037</b>	REV. C
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE <b>CROSSBEAM</b>	SCALE
DE APPR.			NTS
DATE	10.09.15	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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